

Date: Thursday, 06/11/2008 2:31:56 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: OUTER AFT SADDLE		
Job Number	: 43249			Part Number	: D5955		
Estimate Number	: 11080			Drawing Number	: D5955 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 27/11/2008		
Previous Run	: 39795			Qty:	8	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08/11/08</u>						
Comment	: Est Rev:E Re-Format 05-11-29 JLM						
	: Est Rev:F ecn826 06.12.06 ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101013	Saddle Billet
Comment: Qty: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: <u>D38696</u>		
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
Comment: HAAS CNC VERTICAL MACHINING #3		

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

08/11/13

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/11/21

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/11/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/11/2008 2:31:57 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 43249

Part Number: D5955

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M 109152



8X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8-00

OVEN TEMPERATURE: 322 °F

FINISH TIME: 8-30

MF 08/11/24

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 X8

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST. PC 8/11/24 (8)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 43249	
Description: Outer Aft Saddle				Part Number: D5955	
Inspection Dwg: D5955 Rev: B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.247	5.247	5.249	5.249		
D	6.995	7.005		6.996	6.997	6.999	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.749	4.749	4.749		
G	0.315	0.322		0.320	0.320	0.320	0.320		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.054	3.054	3.054	3.054		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.320	0.320	0.320	0.320		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.499	0.500	0.500	0.500		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.508	0.504	0.501	0.500		
T	1.625	1.645		1.635	1.635	1.636	1.635		
U	2.000	2.020		2.007	2.007	2.007	2.007		
V	0.023	0.043		R.033	R.033	R.033	R.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.	10/11/13	Audited by:	J.L.
Date:	08/11/12	08/11/13	Date:	08/11/12

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART AEROSPACE LTD				Work Order: 43249	
Description: Outer Aft Saddle			Part Number: D5955		
Inspection Dwg: D5955 Rev: B			Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		440	440	440	440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.248	5.249	5.248	5.248		
F	4.745	4.755		4.749	4.749	4.748	4.748		
G	0.315	0.322		.321	.321	.321	.321		
H	1.522	1.532		1.524	1.527	1.524	1.524		
I	3.048	3.058		3.052	3.056	3.056	3.056		
J	4.575	4.585		4.579	4.581	4.580	4.580		
K	0.315	0.322		.321	.321	.321	.321		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.499	.500	.499		
N	1.865	1.885		1.885	1.883	1.883	1.883		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.256	2.256	2.256	2.256		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		760	760	760	760		
S	0.490	0.510		.501	.500	.500	.500		
T	1.625	1.645		1.635	1.633	1.635	1.635		
U	2.000	2.020		2.010	2.010	2.010	2.010		
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>KJL</i>	Audited by:	<i>JL</i>
Date:	08/11/13	Date:	08/11/21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD <i>KJ</i>	<i>DA</i>

**DART**

DESIGN BW	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE		SCALE 1:4

REV	DATE	DESCRIPTION
A	97.05.06	NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

Technical drawing of D5955 Outer Aft Saddle. The drawing includes:

- Material:** 0.075 X 45° ALL AROUND BOTH SIDES
- Dimensions:**
  - Top view: 0.063, 0.500, R0.500, R0.063, R0.025, 0.188, 0.313, 0.033 X 45° CHAMFER (2 PLACES).
  - Front view: 0.500, 4.750, 2.375, 5.250, 0.620, 3.053, 4.580, R2.000, R2.250, 8.000, 1.250, 2.050, 130°.
  - Bottom view: 0.500, 0.660, R0.500, 0.438, 4 PLACES, 0.500, 1.750, 5.250, 7.000, 8.000.
- Processing:**
  - ENgrave part no. and batch no. with min rad of 0.010 to max depth of 0.010.
  - DRILL Ø 0.316 THRU Ø 0.750 SPOT FACE (2 PLACES).
  - ENgrave DART logo with min rad of 0.250 to max depth of 0.015.
  - 0.040 X 45° CHAMFER ALL AROUND.
- Grain Direction:** GRAIN DIRECTION
- Detail B:** SCALE 1:1
- View A-A:** Shows a cross-section with a 130° angle and a 2.050 dimension.
- Notes:**
  - ADD TOLERANCE TO R2.000; ADD 0.363 DIM
  - 0.363
  - 0.033 X 45° CHAMFER (2 PLACES)
  - 0.040 X 45° CHAMFER ALL AROUND
  - SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

**NOTES:**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

• CHAMFER  
ND  
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ENGINEERING  
UNCONTROLLED COPY  
AMENDMENT

**ISOMETRIC VIEW**

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